

Work Order ID 64559

Wednesday, December 08, 2010 10:25:00 A



Page 1

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Stop



Start Date: 12/8/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

MC

Date:

10-12-8

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2661

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Fixturing Inspection last completed
~~6/15/10~~ by *me* ☐ 1-Machine Step No 1 of Folio and visually inspect as
per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually
inspect as per attached Dimension

SL 11/10/10

8

8

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11/10/10

8

8

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/10/10

8

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 12/22/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M 117745 320°F

10:45

11:15

8 0 BR 11-7-H.

8x 0 M 117745 7/07

W/O:		WORK ORDER CHANGES					
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Page 3

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Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 12/8/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8 0 21 11/07/07

170



Packaging

Packaging

Identify as per dwg & Stock Location: 435

0.00

Memo

0.00

11/7/08 SPC

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/7/11 MF
11-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 28, 2011 8:39:00 AM

Page 1

Work Order ID: 64559

Parent Item: D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206



Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C000.11.01: Removed P/O for Powder Coat - in house process: EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003		Manufactured	No				Each	31.0000		8			
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Saddle Billet, 7075



11/06/30

Location

Loc Qty

Loc Code

MAT

5

69701

5

MAT040

20

69678

20

MAT45

6

68172

6

66964

4

4

DART AEROSPACE LTD	Work Order:	111559
Description: 206 Saddle, Outboard, Left side	Part Number:	D2661-1
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.128	.139	.135	.135		
B	0.100	0.140		.140	.120	.121	.120		
C	1.250	1.270	1.145	1.135	1.133	1.134	1.135		
D	0.615	0.685		.660	.660	.660	.660		
E	0.240	0.260		.250	.251	.251	.250		
F	1.437	1.467	1.343	1.325	1.322	1.325	1.323		
G	0.210	0.230		.224	.224	.224	.224		
H	0.100	0.180		.138	.125	.125	.125		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.545	1.543	1.544	1.545		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.118	.112	.112	.118		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.513	.513	.513	.513		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.313	.313	.313	.313		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.789	.796	.797	.797		
W	0.540	0.560		.543	.551	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.930	.921	.921	.922		
AA	0.490	0.510		.509	.492	.499	.499		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	JL	Audited by:	AMR
Date:	11/06/29	Date:	11/06/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

158
129
157

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>114559</i>
Description: 206 Saddle, Outboard, Left side		Part Number: D2661-1
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.100	0.140		.137	.134	.136	.135		
B	0.100	0.140		.119	.120	.120	.119		
C	1.250	1.270	1.195	1.130	1.134	1.132	1.133		
D	0.615	0.685		.660	.660	.660	.660		
E	0.240	0.260		.255	.252	.254	.254		
F	1.437	1.467	1.545/1.513	1.325	1.324	1.325	1.325		
G	0.210	0.230		.224	.224	.224	.224		
H	0.100	0.180		.125	.125	.125	.125		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.570	1.574	1.572	1.573		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.110	.114	.113	.113		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.513	.513	.513	.513		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
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W	0.540	0.560		.550	.551	.551	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.922	.922	.923	.922		
AA	0.490	0.510		.499	.499	.500	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 11/06/30

Audited by: <i>[Signature]</i>
Date: 11/06/30

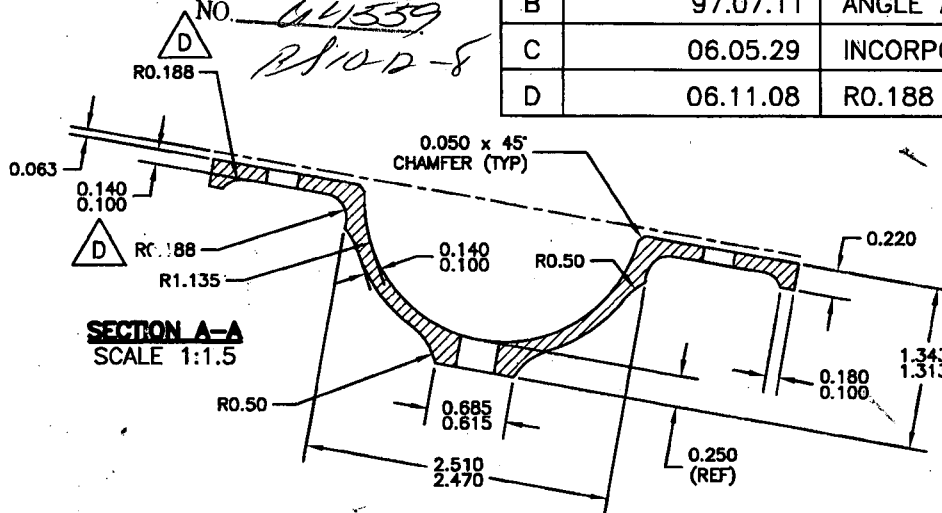
Rev	Date	Change	Revised by	Approved
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E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

DART

COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTWITHOUT NOTICE
WORK ORDERNO. 4413392100-8

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2661	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE OUTSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

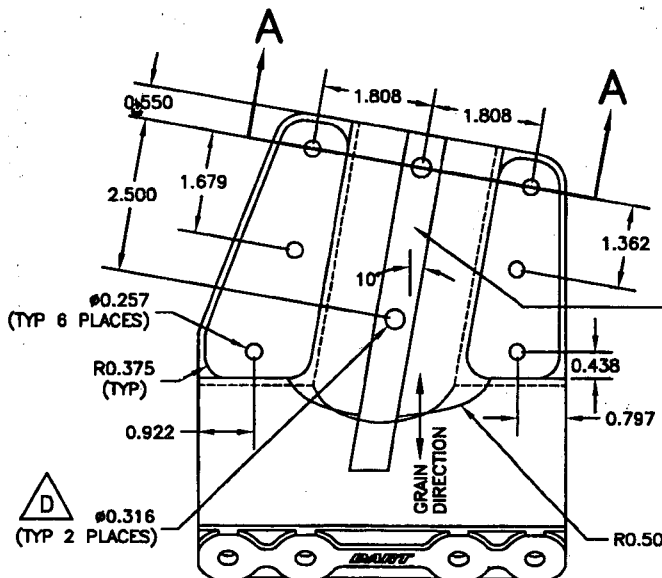
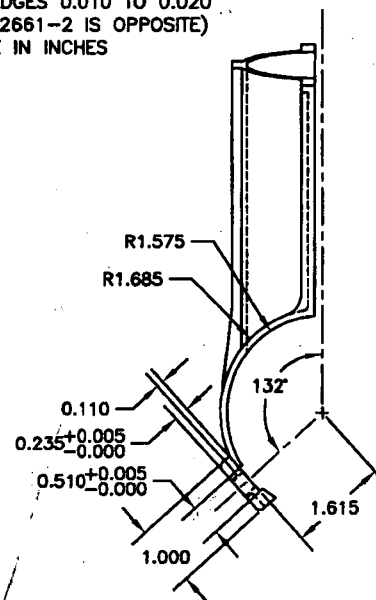


RELEASED

07.02.12

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010**D2661-1 SADDLE OUTSIDE**

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